

NUR-19-7617



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5609-1

Job Sheet 192491



Part No: D5609-1

Job Qty: 1 pcs

Part Name: EC130 Fwd Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/26/19

Job Tracking No:

Due Date: 4/29/19

Created By: Steven Hemmerich

Type: Stock

Description:

Note: TBD D5609 REV.A IPP REV:A 18.06.20 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Handfinish - 1 - Chemical	1 pcs	4/29/19		0.00	0.17	Handfinish - 1 - 1		BEB 19-03-28
							Handfinish - 1 - 2		
							Handfinish - 1 - 3		
							Handfinish - 1 - 4		
							Handfinish - 1 - 5		
							Handfinish - 1 - 6		
							Handfinish - 1 - 7		
							Handfinish - 1 - 8		
							Handfinish - 1 - 9		
							Handfinish - 1 - 10		
							Handfinish - 1 - 11		
							Handfinish - 1 - 12		
							Handfinish - 1 - 13		
							Handfinish - 1 - 14		
							Handfinish - 1 - 15		
							Handfinish - 1 - 16		
							Handfinish - 1 - 17		
							Handfinish - 1 - 18		
							Handfinish - 1 - 19		
							Handfinish - 1 - 20		
							Handfinish - 1 - 21		
							Handfinish - 1 - 22		
105	QC 5	1 pcs	4/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		



Container No: S167559



Part: D5609-1

Job No: 192491

Serial No/Batch: S167559

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/18/19

#104

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P.T.O.

5

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	19-08-31
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
110	Outsource - 23 - Tube Bending	1 pcs	4/29/19	PAR005-VU	36-19
120	Packaging 2-1 - Receive - B4B	1 pcs	4/29/19	0.00 0.00	JUN 18 2019
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
130	QC 6	1 pcs	4/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
140	Packaging 3-1 - Stock - B4B	1 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	BB 9/3/2019
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - FG	1 pcs	4/29/19	0.00 0.00	QC 21 - FG - 21	DAB 21 SEP 03 2019
				QC 21 - FG - 70	9-50
				QC 21 - SA - 53	

Part Op 100 - (Chemical Conversion Coat per QSI005 4.1), Alodine prior to sending the extrusion to an outside vendor.
 Descriptions: 105 - ***IDENTIFY SERIAL # BY USING A MARKER IN THE MIDDLE OF TUBE AT CONTAINER CREATION***
 INSPECT ALODINE AND MAKE SURE TUBE IS IDENTIFY WITH MARKER IN THE MIDDLE OF THE TUBE
 110 - Issue P/O: 42043 Manufacture D5609-1 as per dwg (Bend, Remove excess material after bending)
 Ship extrusion D6029-120 ***INSPECTION REPORT REQUIRED FOR EACH TUBE. MUST BE TRACEABLE TO INDIVIDUAL SERIAL NUMBER*** **AS PER DWG NOTE 9, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
 120 - (Receive & Inspect for Damage & Mat'l Certs), Ensure material release note is attached *****CHECK ID OF CUFF USING DT10434 GO PLUG GAUGE AS PER NOTE 11*****
 130 - (QC6- All purchased or subcontracted products), *****CHECK ID OF CUFF USING DT10434 GO PLUG GAUGE AS PER NOTE 11*****
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6029-120	Tube, Seamless	1 pcs (1 ea)	100-Handfinish - 1 - Chemical	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Handfinish - 1 - Chemical	D6029-120	1	22	0

Part Specifications

Specifications could not be found.

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043043



Supplier: PAR005-VU
Parker Fabrication Inc
501 East Courtland
Morton, IL 61550-9043 USA
Phone: 309-266-8413
Fax: 309-266-7231

PO No: PO043043

PO Date: 4/1/19

Due Date: 5/16/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Revision

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Journey Freight

Pynt Terms: Net 30

Freight Terms: Prepaid

Special Comments: Ensure that parts are serialized in such a way as to easily match tube to its corresponding paper work.

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	192508	D5609-1	EC130 Fwd Crosstube Issue P/O: Manufacture D5609-1 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6029-120** ***INSPECTION REPORT REQUIRED FOR EACH TUBE. MUST BE TRACEABLE TO INDIVIDUAL SERIAL NUMBER**** ***AS PER DWG NOTE 9, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42

1X JUN 18 2019



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER

PO043043



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
Line Item Note FWD X-TUBE 13 each at your location. Ensure that parts are serialized in such a way as to easily match tube to its corresponding paper work.											
192507	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192506	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192505	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192504	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192502	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192499	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192492	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192491	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192490	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192489	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192488	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
192486	1 X		JUN 18 2019	Firmed		5/16/19	1 pcs	0 pcs	1 pcs	\$269.42/pcs	\$269.42
Sub Total:							13	0	13		\$3,502.46

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Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043043



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
2	192510	D5611-1	EC130 Skidtube Issue P/O: Manufacture D5611-1 as per dwg (Bend,Swag, Remove excess material after bending) **Ship extrusion D6031-120** ***INSPECTION REPORT REQUIRED FOR EACH TUBE. MUST BE TRACEABLE TO INDIVIDUAL SERIAL NUMBER**** ***AS PER DWG NOTE 8, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69

1 X JUN 18 2019

Line Item Note SKID TUBE 7 each at your location, 7 in this shipment.

Ensure that parts are serialized in such a way as to easily match tube to its corresponding paper work.

192525	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192526	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192527	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192528	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192529	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192530	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192535	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192536	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192531	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192532	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192533	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
192534	1 X	JUN 18 2019	Firmed	-	5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043043



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
	192537		JUN 18 2019	Filled		5/16/19	1 pcs	0 pcs	1 pcs	\$306.69/pcs	\$306.69
Sub Total:							14	0	14		\$4,293.66

Grand Total: \$7,796.12

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

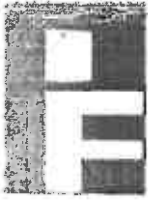
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/3/19 12:27 PM dart.Lussier.Patrick



Parker Fabrication, Inc.
501 East Courtland
Morton, IL 61550-9043

Ph: 309.266.8413

Fax: 309.266.7231

1 of 3
Pack List

Number: **123373**

Date: 10-Jun-19

To

Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
Canada

Ship To

Steven Hemmerich
Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
Canada

Ph: 1 613 632-5200

Ph: 1 613 632-5200

Terms		Ship Via	
Net 30		Freight Collect	
Quantity	Description		
✓ 13 ea	Part: D5609-1 ✓ EC130 Fwd Crosstube	Rev: A	
	SO: 70913	PO: PO043043 ✓	Line: 001
14 ea	Part: D5611-1 EC130 Skidtube	Rev: A	
	SO: 70913	PO: PO043043	Line: 002
	Thank you for your business!		
	RECEIVED JUN 13 2019 DART AEROSPACE LTD.		

Certificate of Conformance (CoC)

Form F-4003
Page 1 of 1
Last Revised:
3/09/2018

Supplier Name: Parker Fabrication
Supplier Number: _____
Part Description: FWD X-TUBE (EC130)

Part Number: D5609 ✓
Drawing Number: D5609

Revision: A

Purchase Order #: PO043043 ✓

Quantity: 13 ✓

Serial Number(s): _____ (if applicable)

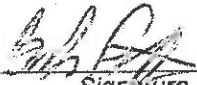
Lot/Heat Number: _____ (if applicable)

All technical requirements of the contract are satisfied. Quality and performance are in accordance with the contract, the specifications, and all references and associated contractual drawings and documents.

I, as a supplier to Dart Aerospace, acknowledge and certify the material covered under this document is produced in accordance with the following:

- ☒ All Contractual "Flow Down" Requirements
- ☒ Supplier Standards Guide
- ☒ Global Supplier Quality Manual
- ☒ Product Conformance
- ☒ Free of Counterfeit Material

(Acknowledge by marking the boxes)

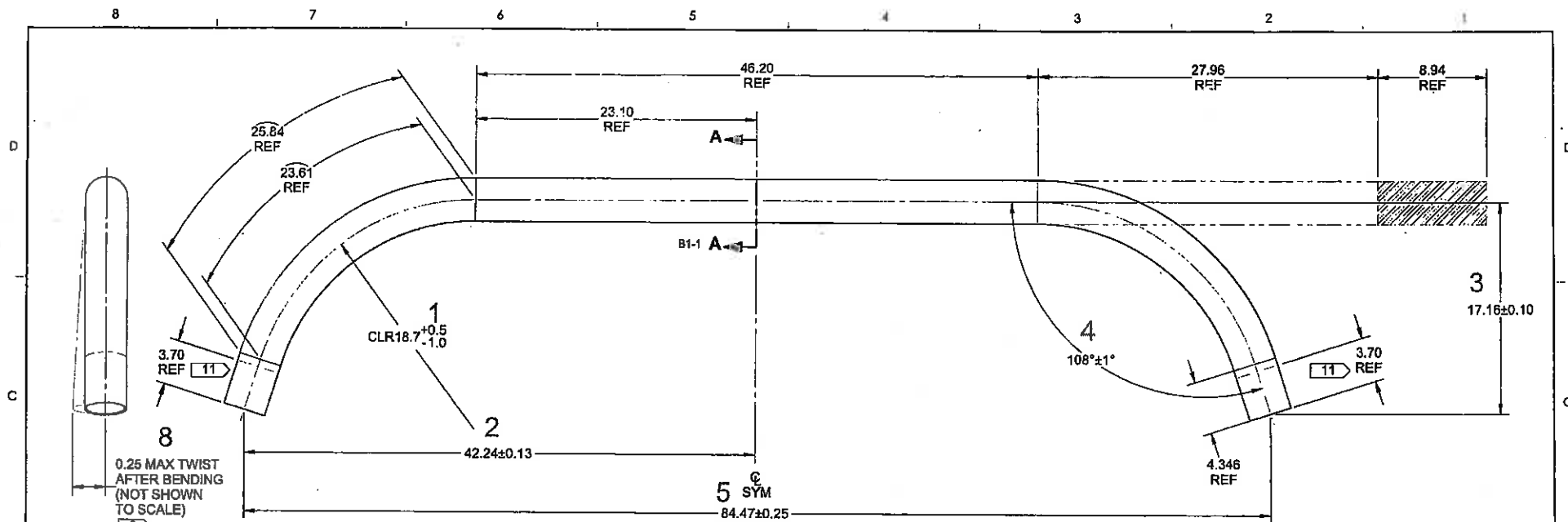

Signature

Quality Manager
Title

5/31/2019
Completion Date

This certifies the parts/items/materials identified above conform to all applicable drawings and/or specifications as evidenced by reports or other documentation on file and all other purchase order and quality requirements have been met.

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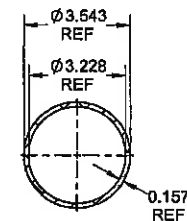


D5609-1 FWD X-TUBE (EC130)

CONTROLLED COPY

RELEASED

2018 OCT 02
ECN 18-617



SECTION A-A D5-1
SCALE 2X

NOTES:

- 1) MATERIAL: MAKE FROM D6029-120
STRAIGHT LENGTH = 120.00" (BEFORE BENDING / TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT EXTRUSION PER DART QSI 005 4.1 PRIOR TO SENDING EXTRUSION TO OUTSIDE VENDOR
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 17.36lbs
- 8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 10) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.
- 11) CHECK MIN ID USING TOOL DT10434 FOR 3.70 LENGTH.

APPROVED

A	NEW ISSUE		ZF	18.05.04
REV.		DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	ZF			
CHECKED	MW	DRAWING NO.		REV. A
MFG. APPR.	JFS	D5609		SHEET 1 OF 1
APPROVED	NO	TITLE		SCALE
DE APPR.	CP	FWD X-TUBE (EC130)		NTS
DATE	18.05.04	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

Production Part Approval Dimensional Test Results

[illegible]

Production Part Approval Dimensional Test Results

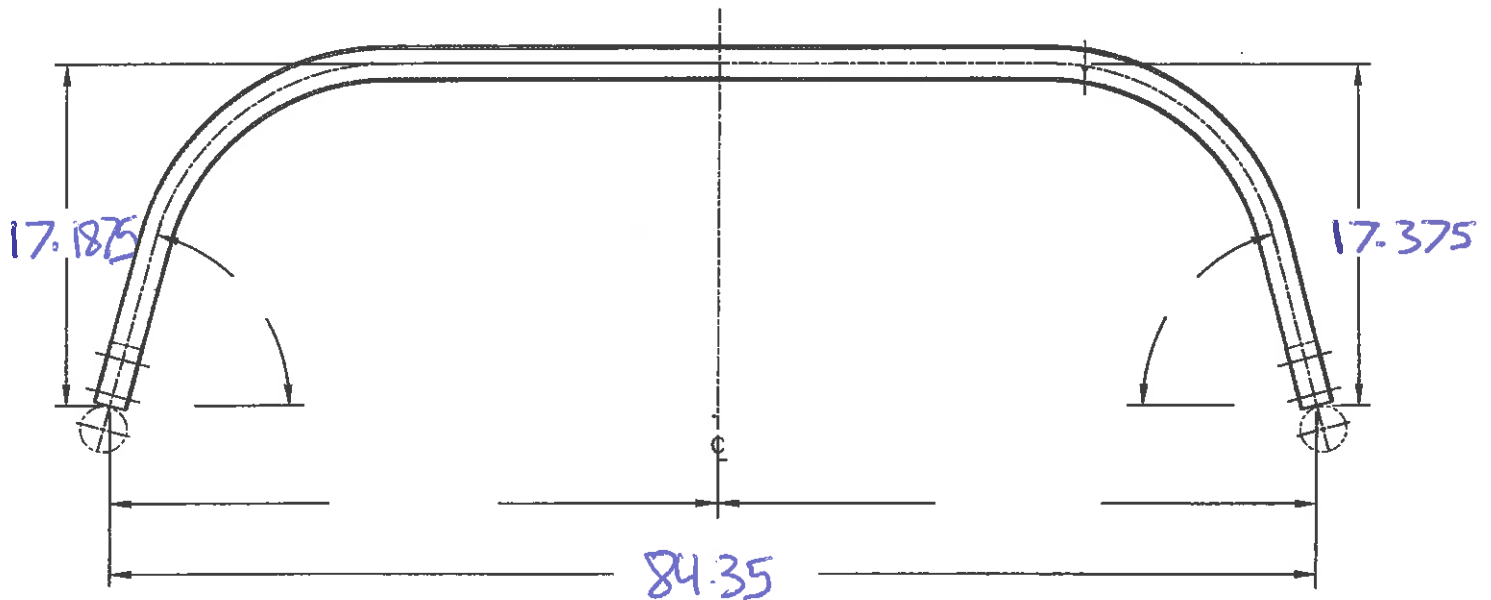
[illegible]

Production Part Approval Dimensional Test Results

[illegible]

DART AEROSPACE LTD		Work Order:	192491
Description:		Part Number:	
Inspection Dwg:		Rev:	Page 1 of 1

Required Dimension	Min	Max
Height		
1/2 Span		
Angle		
Total Span		
Bending Passes		
Crushing		



	Side A	Side B
Bending Passes		
Crushing		
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	06.09.19	Reformat; QC level revised	KJ/JM	
C	07.02.06	Reformat	KJ/JM	
D	12.02.15	Added bending passes and crushing	KJ	
E	12.03.07	Revised comments table	KJ	

LL Date: Oct 28/19



NCR No. 9-7657

Route update only

Job: 192491		DISPOSITION		DEPARTMENT/PROCESS							
Part No. DS609-1		Rework ☒		Skid-tube ☐		Cross tube ☒		Eng. (Non-AW) ☐		Engineering ☐	
		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Water Jet ☐	
		Use-as-is ☐		Large Fab ☐		Finishing ☐		Rec/Store/Packaging ☐		Supplier ☐	
										Quality ☐	
Date: 19-08-13		Sequence #:		QTY Affected:				MRB (QSI042)			
Description Work Order Deviation				Disposition				Completed By			
Height on one side measured 17.375 dwg 17.16 ± 0.1				Trim of grind one side back into tolerance post grinding measurement at 17.1875				BB, 19-09-05			
								Lead hand / Supervisor			
								DAS 47 19-09-05			
								9-89			
								QC / QA Coordinator			
								DAS 33 0-89			
								AUG 30 2019			
Root Cause		FAULT CATEGORY									
Operator ☒		☐ Pressure/Forced		☐ Contamination		☐ Power Loss/Surge		☐ Positioned Wrong			
Manufacturing Process ☐		☐ Bending		☐ Misaligned/off center		☐ Folio/Program		☒ Outside Tolerance			
Equip/Tooling ☐		☐ Crushing		☐ BOM/Route		☐ Grain Direction		☐ Drawing			
Handling/Preservation ☐		☐ Cracks		☐ Broken/Damage/Defect		☐ Weld		☐ Finish			
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Wrong Stock Pulled		☐ Part Lost/Missing			
Product Improvement ☐		☐ Marks/Chatter		☐ Drill Holes		☐ Out of Sequence		☐ Misread			
Process Improvement ☐		☐ Mislabeled		☐ Fit/Function		☐ Off-set/Set-up					
Human Factors ☐		Other/Details:									